

Work Order ID **77485**

77485

Page 1

December-08-11 1:39:33 PM

Item ID: D2611 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearing
 Start Date: 08/12/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 22/12/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2611	Rev C								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 15648 Purchase part as per Dwg D2611 Possible supplier:
 McMasterP/N: 63215K34 Material release note required

CL 11/12/12 40

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure certificate of conformity is attached

11/12/14 (40)

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

counts
(40)

Switz 11/12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77485

77485

Page 2

December-08-11 1:39:33 PM

Item ID: D2611 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearing
 Start Date: 08/12/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 22/12/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>18</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten: 11/12/20 40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-08-11 1:39:37 PM

Page 1

Work Order ID: 77485

77485

Parent Item: D2611

D2611

Parent Item Name: Bearing

Start Date: 08/12/2011

Required Date: 22/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:B99.06.23Re-formatDM
Change to SS; Change Supplier- Rev.C 07.03.14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

63215K34

Purchased

No

Each

0.0000

40

63215K34

**

Bearing

Rec'd 1/14 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

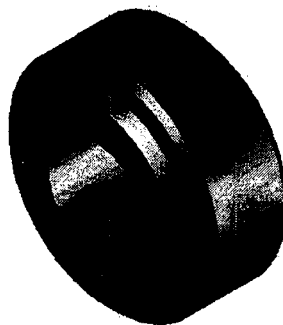
NOTE: Date & initial all entries



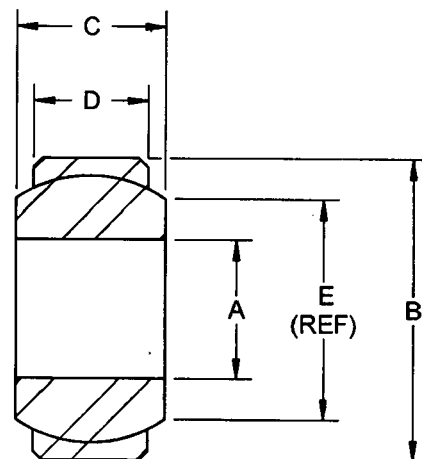
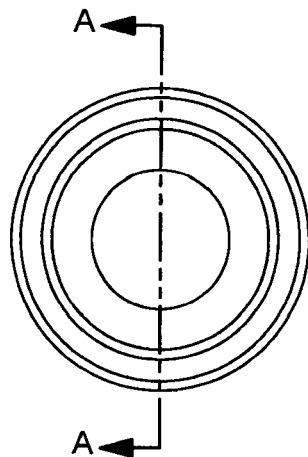
DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2611	REV. C SHEET 1 OF 1
DATE 06.09.20		TITLE BEARING	SCALE NTS
REV	DATE	DESCRIPTION	
A	97.07.31	NEW ISSUE	
B	01.07.04	RE-DRAWN	
C	06.09.20	CHANGE TO SS; CHANGE SUPPLIER	

SPECIFICATION CONTROL DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77485 *M.C.J*
11/12/08



RELEASED
06.11.17 *#*



SECTION A-A

A	B	C	D	E (REF)	POSSIBLE SUPPLIER
0.375	0.813	0.406	0.313	0.592	McMASTER-CARR P/N 63215K34

NOTES:

- 1) STAINLESS STEEL BALL JOINT SWIVEL BEARING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

COPYRIGHT © 1997 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15648

Purchase Order Date 12/12/11

PO Print Date 12/12/11

Page Number 1 of 3

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name

Vendor Phone

330 995 5500

Vendor Fax

330 995 9600

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

EX 12/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	63215K34	Bearing	12/14/11 Yes	40.00 Each	FedEx PI collect	\$17.2400	\$689.60
Special Inst:			AS PER DWG D2611 REV. C B77485				
2	92311A639	SS SET SCREW	12/14/11 Yes	200.00 Each	FedEx PI collect	\$0.6619	\$132.38
Special Inst:			AS PER DWG D2747 REV. B B77484				
3	91525A120	washer	12/14/11 Yes	50.00 Each	FedEx PI collect	\$0.2664	\$13.32
Special Inst:			AS PER DWG D3456 REV. A B77486				
4	9381T24 S HOOKS		12/14/11 Yes	30.00 Each	FedEx PI collect	\$3.8700	\$116.10

CERTIFICATE OF CONFORMITY
AND DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 3

Change Date: 12/12/11

10 Aurora Industrial Pkwy
Aurora OH 44202-8087
30-995-5500
a.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Order Placed By
Clavoie

12/12/2011

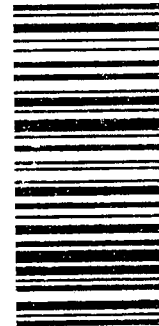
McMaster-Carr Number
6870091-02

Part Number	Description	Ordered	Shipped
63215K34	Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Your Part Number: B77485	40 Each	40
	Unit Price: \$17.24 Extended Price: \$689.60		
92311A639	Type 18-8 Stainless Steel Cup Point Socket Set Screw, 3/8"-24 Thread, 1" Length, Packs of 10 Your Part Number: B77484	20 Packs	20
	Unit Price: \$5.91 Extended Price: \$118.20		
91525A120	Type 316 Stainless Steel Large-Diameter Flat Washer, 1/4" Screw Size, 1" OD, .04"-.06" Thick, Packs of 25 Your Part Number: B77486	2 Packs	2
	Unit Price: \$6.66 Extended Price: \$13.32		
9381T24	Zinc-Plated Steel Open End S-Hook, 1/8" Diameter, 28# Work Load Limit, Packs of 25	30 Packs	30
	Unit Price: \$3.87 Extended Price: \$116.10		

LNS A84			
3 - 482 - 03	07 - 38	K34	40 EA
2 - 697			
2 - 703			
3 - 293			

Dart Aerospace Ltd

EXP



32 lbs
9 lines

FW1WBP32
12/12/2011
13:39/13:57
115
Cycle 45

1140223308632



Lg

20x20x16

SS-R-0707